

This Page Is Inserted by IFW Operations
and is not a part of the Official Record

BEST AVAILABLE IMAGES

Defective images within this document are accurate representations of the original documents submitted by the applicant.

Defects in the images may include (but are not limited to):

- BLACK BORDERS
- TEXT CUT OFF AT TOP, BOTTOM OR SIDES
- FADED TEXT
- ILLEGIBLE TEXT
- SKEWED/SLANTED IMAGES
- COLORED PHOTOS
- BLACK OR VERY BLACK AND WHITE DARK PHOTOS
- GRAY SCALE DOCUMENTS

IMAGES ARE BEST AVAILABLE COPY.

**As rescanning documents *will not* correct images,
please do not report the images to the
Image Problem Mailbox.**

(12) INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(19) World Intellectual Property Organization
International Bureau



(43) International Publication Date
31 October 2002 (31.10.2002)

(10) International Publication Number
PCT
WO 02/086381 A1

(51) International Patent Classification⁷: **F17D 1/16**, 1/17,
1/04, 1/04, F15D 1/06, C10L 3/00, C09K 3/00, C10L 1/18

(21) International Application Number: **PCT/US02/07564**

(22) International Filing Date: **6 March 2002 (06.03.2002)**

(25) Filing Language: **English**

(26) Publication Language: **English**

(30) Priority Data:
60/286,228 24 April 2001 (24.04.2001) **US**
09/944,837 30 August 2001 (30.08.2001) **US**

(71) Applicant: **BAKER HUGHES INCORPORATED**
[US/US]; Suite 1200, 3900 Essex Lane, Houston, TX
77027 (US).

(72) Inventors: **JOVANCICEVIC, Vladimir**; 2231 Shadow
Crest Drive, Richmond, TX 77469 (US). **BARTRIP,**
Keith, A.; 510 Pin Oak Street, Baytown, TX 77520 (US).

(74) Agent: **LITTLEFIELD, Stephen, A.**; Baker Petrolite Di-
vision, Baker Hughes Inc., Division Intellectual Property
Counsel, 12645 West Airport Boulevard, Sugar Land, TX
77478 (US).

(81) Designated States (*national*): AE, AG, AL, AM, AT, AU,
AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CO, CR, CU,
CZ, DE, DK, DM, DZ, EC, EE, ES, FI, GB, GD, GE, GH,
GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC,
LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW,
MX, MZ, NO, NZ, OM, PH, PL, PT, RO, RU, SD, SE, SG,
SI, SK, SL, TJ, TM, TN, TR, TZ, UA, UG, UZ, VN, YU,
ZA, ZM, ZW.

(84) Designated States (*regional*): ARIPO patent (GH, GM,
KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZM, ZW),
Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM),
European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR,
GB, GR, IE, IT, LU, MC, NL, PT, SE, TR), OAPI patent
(BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR,
NE, SN, TD, TG).

Published:

- with international search report
- before the expiration of the time limit for amending the
claims and to be republished in the event of receipt of
amendments

*For two-letter codes and other abbreviations, refer to the "Guid-
ance Notes on Codes and Abbreviations" appearing at the begin-
ning of each regular issue of the PCT Gazette.*



WO 02/086381 A1

(54) Title: **DRAG REDUCTION USING FATTY ACIDS**

(57) Abstract: Non-polymeric fatty acid drag reducing agents are described herein. These additives are useful to reduce drag in hydrocarbon fluids and multiphase fluids of hydrocarbon(s) and water. No injection probes or other special equipment is expected to be required to introduce the drag reducing agent into the liquid stream, nor is grinding (cryogenic or otherwise) of the additive necessary to form a suitable drag reducing agent. The drag reducing additives of the invention are not subject to shear degradation and do not cause undesirable changes in the emulsion or fluid quality of the fluid being treated, or undesirable foaming. The drag reducing additives include fatty acids, alkoxyated derivatives of fatty acids, organic and inorganic salts of fatty acids and alkoxyated derivatives thereof, and esters of fatty acids and alkoxyated derivatives thereof, and mixtures thereof.

DRAG REDUCTION USING FATTY ACIDS

Field of the Invention

The invention relates to agents to be added to fluids flowing through a conduit to reduce the drag therethrough, and most particularly relates, in one non-limiting embodiment, to non-polymeric drag reducing agents (DRAs) for liquids such as hydrocarbons, and emulsions of water and hydrocarbons.

Background of the Invention

The use of polyalpha-olefins or copolymers thereof to reduce the drag of a hydrocarbon flowing through a conduit, and hence the energy requirements for such fluid hydrocarbon transportation, is well known. These drag reducing agents or DRAs have taken various forms in the past, including slurries of ground polymer particulates. A problem generally experienced with simply grinding the polyalpha-olefins (PAOs) is that the particles will "cold flow" or stick together after the passage of time, thus making it impossible to place the PAO in the hydrocarbon in a form that will dissolve or otherwise mix with the hydrocarbon in an efficient manner. Further, the grinding process irreversibly degrades the polymer, thereby reducing the drag reduction efficiency of the polymer.

One common solution to preventing cold flow is to coat the ground polymer particles with an anti-agglomerating agent. Cryogenic grinding of the polymers to produce the particles prior to or simultaneously with coating with an anti-agglomerating agent has also been used. However, some powdered or particulate DRA slurries require special equipment for preparation, storage and injection into a conduit to ensure that the DRA is completely dissolved in the hydrocarbon stream.

Gel or solution DRAs have also been tried in the past. However, these drag reducing gels also demand specialized injection equipment, as well as

pressurized delivery systems. They are also limited to about 10% polymer as a maximum concentration in a carrier fluid due to the high solution viscosity of these DRAs. Thus, transportation costs of the DRA are considerable, since up to about 90% of the volume being transported and handled is inert material.

Further, polymeric DRAs additionally suffer from the problem that the high molecular weight polymer molecules can be irreversibly degraded (reduced in size and thus effectiveness) when subjected to conditions of high shear, such as when they pass through a pump. Additionally, some polymeric DRAs can cause undesirable changes in emulsion or fluid quality, or cause foaming problems when used to reduce the drag of multiphase liquids.

Surfactants, such as quaternary ammonium salt cationic surfactants, are known drag reducing agents in aqueous (non-hydrocarbon) systems and have the advantage over polymeric DRAs in that they do not degrade irreversibly when sheared. In contrast, flow-induced structures in surfactant solutions are reversible.

Thus, it would be desirable if a drag reducing agent could be developed which rapidly dissolves in the flowing hydrocarbon or emulsion, which could minimize or eliminate the need for special equipment for preparation and incorporation into the hydrocarbon or emulsion, and which could avoid shear degradation. It would be desirable to develop a drag reducing agent that does not cold flow and thus requires the use of cryogenic grinding and/or the extra addition of an anti-agglomeration additive.

Summary of the Invention

An object of the invention is to provide a DRA that does not require the use of a polymeric material.

Other objects of the invention include providing a DRA that can be readily manufactured and which does not require special equipment for placement in a conduit transporting hydrocarbons or other fluids.

Another object of the invention is to provide a DRA that does not cold flow upon standing and is stable.

In carrying out these and other objects of the invention, there is provided, in one form, a method of reducing drag of a fluid involving first providing a fluid, and then adding to the fluid an amount of an additive effective to reduce the drag of the fluid. The additive is a fatty acid, an alkoxyated derivative of a fatty acid, an organic or inorganic salt of a fatty acid or an alkoxyated derivative thereof, or an ester of a fatty acid or an alkoxyated derivative thereof, and mixtures thereof.

Detailed Description of the Invention

The present invention relates to methods and compositions for reducing drag in multiphase flowlines (for example oil/water, water/oil, oil/water/gas) in oil and gas production systems. It is expected that the invention could apply to any hydrocarbon fluid flowing in a pipeline, whether or not water is present. It will be appreciated that by the term "hydrocarbon fluid", it is expected that oxygenated hydrocarbons such as methanol, ethanol, ethers, and the like may be included within the definition. The term "hydrocarbon fluid" also means any fluid that contains hydrocarbons, as defined herein to also include oxygenated hydrocarbons.

Many oil and gas production systems (e.g. those found in deep water rigs of the Gulf of Mexico) are limited in their production due to pressure drop in the flowlines under turbulent flow regime. The drag reducing methods of the invention comprise applying additives to the system by either batch or continuous treatments at high enough concentrations to produce the desired reduction in drag and/or increase in flow for the same amount of motive

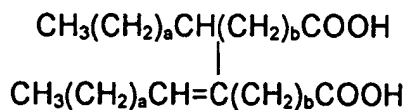
energy. The compositions containing the additive are used effectively by maintaining drag reduction effectiveness over an extended period of time. The use of these types of additives present distinct advantages over the use of conventional polymeric drag reducers including the facts that they are not shear sensitive and do not cause undesirable changes in emulsion, foaming or fluid quality. Without wishing to be limited to any particular mechanism of operation, the microstructures or associations between the molecules of the inventive additives are believed to reform after the fluid is sheared. Reduction in pressure drop in gas and oil multiphase flowlines by using fatty acid and/or fatty acid derivatives allows operators to increase production. The oil/water solubility and/or dispersibility characteristics of the additive can be varied to allow their use in a broad range of oil/water ratios. A mixture of additives, e.g. tall oil fatty polyacids, with various oil/water solubilities can be used to cover a wide range of applications.

The drag reducing additives of this invention have the basic chemical structures of fatty acids, namely a hydrocarbon moiety having one or more carboxylic acid groups ($-\text{COOH}$). In one non-limiting embodiment, the number of carbon atoms in the carboxylic acid range from about 4 to about 100, preferably from about 8 to about 64 carbon atoms. In one non-limiting embodiment of the invention, linear and branched saturated and unsaturated carboxylic acids are included as additives of the invention. Such fatty acids may have a carbon number range of from 4 to 34, preferably from 8 to 20. Specific examples of such fatty acids include, but are not necessarily limited to, oleic acid, linoleic acid, stearic acid, palmitic acid, and the like.

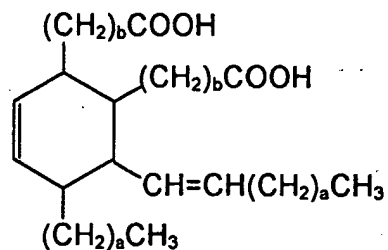
The additives of this invention may also include alkoxylated derivatives of fatty acids. By "alkoxylated fatty acid derivative" is meant any fatty acid that has been reacted with an alkoxide using known or future methods. The alkoxide may include, but is not necessarily limited to ethylene oxide, propylene oxide, butylene oxide and mixtures thereof. In one embodiment of

the invention, the extent of alkoxylation should not be so great as to interfere with the objectives of the invention, which include solubility in the fluid. In one non-limiting example, the extent of alkoxylation may range from about 1 to about 100 alkoxy units, preferably from about 5 to about 20 alkoxy units. Again, the alkoxy units may be mixed types, and may be present in blocks or random arrangement.

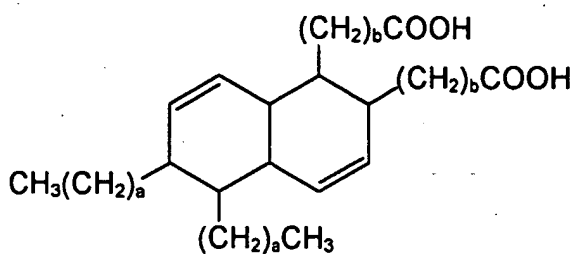
The basic chemical structure of the tall oil fatty dimer acid drag reducers of this invention is given below:



Acyclic



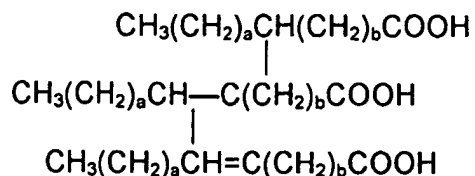
Monocyclic



Bicyclic

where the sum of any one a and b averages 14.

The structure of the trimer acid of the acyclic type is given below:



again where the sum of any one a and b averages 14.

The additives of this invention also include any organic or inorganic salts of the defined fatty acids or alkoxyated fatty acids. Examples of suitable salts include, but are not necessarily limited to amine salts of these materials, amide salts, imidazoline salts, hydroxylamine salts, halide salts (e.g. sodium and/or potassium salts) of these materials and mixtures thereof. Esters of the defined fatty acids or alkoxyated fatty acids are also included within the definitions of the additives of this invention. Suitable esters of this invention include those where the alkyl substituent of the ester group contains from about 1 to about 20 carbon atoms, preferably from about 6 to about 16 carbon atoms. The ester alkyl group may be straight or branched. In one non-limiting embodiment, the corresponding esters of methanol, ethanol, and isopropanol of the dimer and/or trimer acids or other acids are preferred.

In one non-limiting embodiment of this invention, the drag reducing additives are dimer acid, trimer acid, tetramer acid, and/or mixtures thereof. Generally, dimer acid is about C₃₆ and trimer acid is about C₅₄, generally made by dimerizing and trimerizing stearic acid (octadecanoic acid), respectively. However, dimer and trimer fatty acids can be made in general from other monofatty acids. Tall oil derived dimer and trimer acids and mixtures thereof are preferred in one non-limiting embodiment of the invention. For the purposes of this invention, dimer acid, trimer acid, and tetramer acid are oligomers and not polymers.

In one non-limiting embodiment of the invention, the drag reducing additives herein are added in the absence of any polymeric drag reducing additive. In another non-limiting embodiment of the invention, the drag reducing additives are employed in the absence of any other drag reducing additive, *i.e.* one that does not fall within the definitions of this invention. In an additional non-limiting embodiment of the invention, the drag reducing additives are added in the absence of any long chain aluminum soaps. On the other hand, there may be situations or environments where it is advantageous to employ other drag reducing additives together with those of this invention in effective mixtures, such mixtures being within the bounds of this invention.

Compounds such as these fatty acids are known to find use in soaps, lubricants, paints and lacquers, synthetic detergents, emulsifiers, among other applications. The use of fatty acids (and their derivatives) as drag reducers that are the subject of this invention, however, requires substantially higher use concentrations than those for some other uses. The typical use levels in the actual system for drag reduction is approximately 5-10 times higher than that for corrosion inhibitor additives, based on total system fluid, *i.e.* from about 100 to 1000 ppm for methods of this invention, preferably from about 150 to about 600 ppm, and most preferably from about 200 ppm to about 500 ppm. The maximum drag reduction effects observed, including both pressure reduction (ΔP) and flow increase (Q), in the laboratory testing were between 5-20%, depending on oil/water ratio, flow rates and type of test (Torque vs. Flow Loop). It will be appreciated that it is virtually impossible to predict in advance what an effective amount of drag reducing agent would be in any particular circumstance since, as noted, there are a number of interrelated factors that must be considered including, but not necessarily limited to, the type of fluid having its friction characteristics modified, the flow rate of the fluid, the temperature of the fluid, the nature of the DRA, etc. Thus,

the dosage ranges given above and used in the Examples should be understood as illustrative only.

The preferred manner of practicing the invention is batch treatment between two pigs or continuous treatment at the well head or pipeline through umbilical or capillary. In the continuous treatment, the product solution is used at high enough concentration to produce the desired drag reduction without causing emulsion, foaming or other oil/water quality problems.

The fatty acids, esters and salts thereof may be combined with any suitable solvent prior to use as a drag reducing agent. Such solvents include, but are not necessarily limited to, aromatic solvents, aliphatic solvents, alcohols, ethers, esters, water, and mixtures thereof. To further illustrate the invention, the inventive method will be additionally described by way of the following non-limiting Examples, which are intended only to further show specific embodiments of the invention.

EXAMPLE 1

The final tests were carried out in the DRA flow loop with different oil/brine (O/B) ratios. A recirculated DRA flow loop was used to measure drag reduction properties (ΔP , flow, fluid density) of DRAs. The flow loop circulated 30 liters of fluid through a 1/2-inch (1.27 cm) ID stainless steel pipe (4-foot long (1.2 m) section) equipped with a differential pressure transducer. Differential pressure (ΔP), flow rate (Q), fluid density, pressure and temperature were measured continuously during the test. Only the reduction in ΔP accompanied with a corresponding increase in Q as a result of the addition of DRA was considered as an indication of drag reduction.

The mass flow rate and density of fluids were measured using a mass flow meter, while ΔP was measured using a differential pressure transducer. The concentration of DRA was varied from 75-300 ppm. All experiments were carried out at 140°F (60°C) and 100 psi (690 kPa) CO₂. The pressure drop

(ΔP), flow rate (Q), change in pressure drop ($\delta\Delta P$), change in flow rate (δQ) and calculated Fanning friction factor (f) were obtained using product A (tall oil derived dimer-trimer acid) and product B (maleated fatty acid) drag reducers as shown in Table I. The reduction in Fanning friction factor for these two chemicals in 70/30 oil/brine mixture was close to 25%.

TABLE I
DRA Flow Loop Data

DRA	O/B Ratio	ΔP , psi (kPa)	$\delta\Delta P$ (%)	Q, lb/min (kg/min)	δQ	f
Blank	30/70	6.90 (47.6)		126.0 (57.1)		0.0053
	50/50	6.70 (46.1)		115.0 (52.2)		0.047
	70/30	6.50 (44.8)		117.0 (53.7)		0.0041
	90/10	6.10 (42.1)		95.0 (43.1)		0.0055
A	30/70	6.35 (43.8)	-5.2	119.9 (53.4)	4.3	0.0041
	50/50	5.67 (30.1)	-12.8	126.4 (57.3)	8.0	0.0031
	70/30	5.87 (40.5)	-3.8	99.1 (44.9)	4.3	0.0049
	90/10					
B	30/70	6.57 (45.3)	-4.7	130.4 (59.1)	3.5	0.0047
	50/50	6.37 (43.9)	-5.0	119.1 (54.0)	3.6	0.0042
	70/30	6.32 (43.6)	-2.8	119.9 (53.4)	2.5	0.0038
	90/10					

Many modifications may be made in the composition and implementation of this invention without departing from the spirit and scope thereof that are defined only in the appended claims. For example, the exact combination of drag reducing additive(s) and liquid having its friction properties modified may be different from those used here. Additionally, derivatives other than those specifically mentioned may find utility in the methods of this invention. Various combinations of fatty acids or derivatives thereof, alone or together with other materials besides those explicitly mentioned herein, are also expected to find use as drag reducing agents.

Claims

We Claim:

1. A method of reducing drag of a fluid, comprising:
providing a fluid selected from the group consisting of hydrocarbons, mixtures of hydrocarbons and water, and mixtures of hydrocarbons, water and gas; and
adding to the fluid an amount of an additive effective to reduce the drag of the fluid, where the additive is selected from the group consisting of fatty acids, alkoxyated derivatives of fatty acids, organic and inorganic salts of fatty acids and alkoxyated derivatives thereof, and esters of fatty acids and alkoxyated derivatives thereof, and mixtures thereof.
2. The method of claim 1 where the additive averages from about 4 to about 60 carbon atoms.
3. The method of claim 1 where the additive is selected from the group consisting of tall oil derived dimer acid, tall oil derived trimer acid, and mixtures thereof.
4. The method of any one of the above claims where the amount of additive based on the total amount of fluid ranges from about 100 to 1000 ppm.
5. The method of any one of the above claims further comprising adding more than one additive.

6. A reduced drag fluid, comprising:
a fluid selected from the group consisting of hydrocarbons, mixtures of hydrocarbons and water, and mixtures of hydrocarbons, water and gas; and
an amount of an additive effective to reduce the drag of the fluid, where the additive is selected from the group consisting of fatty acids, alkoxylated derivatives of fatty acids, organic and inorganic salts of fatty acids and alkoxylated derivatives thereof, and esters of fatty acids and alkoxylated derivatives thereof, and mixtures thereof.
7. The reduced drag fluid of claim 6 where the additive averages from about 4 to about 60 carbon atoms.
8. The reduced drag fluid of claim 6 where the additive is selected from the group consisting of tall oil derived dimer acid, tall oil derived trimer acid, and mixtures thereof.
9. The reduced drag fluid of claim 6, 7, or 8 where the amount of additive based on the total amount of fluid ranges from about 100 to 1000 ppm.
10. The reduced drag fluid of claim 6, 7, 8, or 9 further comprising more than one additive.

INTERNATIONAL SEARCH REPORT

International Application No
PCT/US 02/07564

A. CLASSIFICATION OF SUBJECT MATTER

IPC 7 F17D1/16 F17D1/17 F17D1/04 F15D1/06 C10L3/00
C09K3/00 C10L1/18

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 F17D F15D C10L C09K

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 6 042 750 A (BURLEW JAMES O) 28 March 2000 (2000-03-28) the whole document ---	1,5,6,10
X	WO 97 01582 A (BAKER HUGHES INC) 16 January 1997 (1997-01-16) claims 5,22 ---	1,2,5-7, 10
X	US 4 958 653 A (LOWTHER FRANK E) 25 September 1990 (1990-09-25) claim 10 ---	1,2,6,7
X	US 3 351 079 A (GIBSON DANIEL L) 7 November 1967 (1967-11-07) table 6B --- -/--	1,2,5-7, 10

☒ Further documents are listed in the continuation of box C.☒ Patent family members are listed in annex.

* Special categories of cited documents:

- *A* document defining the general state of the art which is not considered to be of particular relevance
- *E* earlier document but published on or after the international filing date
- *L* document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)
- *O* document referring to an oral disclosure, use, exhibition or other means
- *P* document published prior to the international filing date but later than the priority date claimed

- *T* later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
- *X* document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
- *Y* document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.
- *&* document member of the same patent family

Date of the actual completion of the international search

5 September 2002

Date of mailing of the international search report

13/09/2002

Name and mailing address of the ISA

European Patent Office, P.B. 5818 Patentaan 2
NL - 2280 HV Rijswijk
Tel: (+31-70) 340-2040, Tx. 31 651 epo nl,
Fax: (+31-70) 340-3016

Authorized officer

de la Morinerie, B

INTERNATIONAL SEARCH REPORT

International Application No

PCT/US 02/07564

C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT		
Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	GB 1 556 688 A (GEN ELECTRIC) 28 November 1979 (1979-11-28) column 6, line 2; claims 1,2,4-8,10,11,13-15; example 5 ---	1,2,5-7, 10
X	FR 2 340 993 A (DU PONT) 9 September 1977 (1977-09-09) the whole document ---	6-8,10
X	GB 839 112 A (EXXON RESEARCH ENGINEERING CO) 29 June 1960 (1960-06-29) the whole document ---	6,7,9,10
X	US 5 183 475 A (CARDIS ANGELINE B ET AL) 2 February 1993 (1993-02-02) the whole document ---	6,7,9,10
X	US 4 426 208 A (PERILSTEIN WARREN L) 17 January 1984 (1984-01-17) the whole document ---	6-10
A	US 3 434 485 A (LUMMUS JAMES L) 25 March 1969 (1969-03-25) table 1 ---	1-10
A	WO 98 16586 A (CONOCO INC) 23 April 1998 (1998-04-23) ---	
A	US 3 361 213 A (SAVINS JOSEPH G) 2 January 1968 (1968-01-02) ---	
A	US 3 667 152 A (ECKERT GEORGE W) 6 June 1972 (1972-06-06) ---	
A	EP 0 471 465 A (ATLANTIC RICHFIELD CO) 19 February 1992 (1992-02-19) -----	

Form PCT/ISA/210 (continuation of second sheet) (July 1992)

INTERNATIONAL SEARCH REPORT

Information on patent family members

International Application No

PCT/US 02/07564

Patent document cited in search report		Publication date	Patent family member(s)	Publication date
US 6042750	A	28-03-2000	NONE	
WO 9701582	A	16-01-1997	US 5733953 A AU 6281096 A EP 0835268 A1 NO 976031 A WO 9701582 A1	31-03-1998 30-01-1997 15-04-1998 13-02-1998 16-01-1997
US 4958653	A	25-09-1990	NONE	
US 3351079	A	07-11-1967	NONE	
GB 1556688	A	28-11-1979	US 4190069 A BE 842669 A1 DE 2624834 A1 FR 2313632 A1 IL 49684 A IT 1078780 B JP 51149304 A MX 3282 E MX 143455 A NL 7606044 A US 4341684 A	26-02-1980 01-10-1976 23-12-1976 31-12-1976 30-09-1979 08-05-1985 22-12-1976 18-08-1980 13-05-1981 08-12-1976 27-07-1982
FR 2340993	A	09-09-1977	CA 1085154 A1 DE 2705799 A1 FR 2340993 A1 JP 52098639 A NL 7701488 A	09-09-1980 18-08-1977 09-09-1977 18-08-1977 16-08-1977
GB 839112	A	29-06-1960	US 2873253 A	10-02-1959
US 5183475	A	02-02-1993	WO 9409093 A1 AU 2873592 A	28-04-1994 09-05-1994
US 4426208	A	17-01-1984	NONE	
US 3434485	A	25-03-1969	NONE	
WO 9816586	A	23-04-1998	US 6172151 B1 AU 4417897 A BR 9711926 A CN 1233271 A EP 0932651 A1 NO 991777 A WO 9816586 A1	09-01-2001 11-05-1998 30-10-2001 27-10-1999 04-08-1999 14-04-1999 23-04-1998
US 3361213	A	02-01-1968	NONE	
US 3667152	A	06-06-1972	AT 301730 B BE 750440 A1 DE 2022585 A1 DK 126508 B ES 379969 A1 FR 2047632 A5 GB 1264058 A NL 7007393 A NO 124781 B	15-08-1972 16-11-1970 26-11-1970 23-07-1973 01-04-1973 12-03-1971 16-02-1972 25-11-1970 05-06-1972

INTERNATIONAL SEARCH REPORT

Information on patent family members

International Application No

PCT/US 02/07564

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
US 3667152	A	SE 353918 B	19-02-1973
EP 0471465	A	19-02-1992	
		US 5020561 A	04-06-1991
		CA 2043465 A1	14-02-1992
		DE 69105868 D1	26-01-1995
		DE 69105868 T2	27-04-1995
		EP 0471465 A2	19-02-1992
		NO 913104 A ,B,	14-02-1992

Form PCT/ISA/210 (patent family annex) (July 1992)